

Work Order ID 154328

Thursday, December 08, 2016 11:15:33 AM

154328

Page 1

Item ID: D5406-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Connector

Start Date: 12/2/2016 Start Qty: 42.00

42

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 42.00

42

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: DEC 09 2016

Tooling:

Date:

Run Start ***NR1***QC: 9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5406	REV A

100

0.03

100

FLOW WATER JET

Waterjet

Memo

0.35

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(46)

Dec 16 / 12 / 17

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.07

Quality Control

(46)

Dec 16 / 12 / 17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Page 2

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Accept

N900040100

Setup Start

NS1

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Item Name: Connector

Start Date: 12/2/2016 Start Qty: 42.00

42

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 42.00

42

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.14

Quality Control

461612-20

DAS

9

9-89

150

Identify as per dwg & Stock Location: St/68

0.00

150

Packaging

Memo

0.07

Packaging

LOCATION : GA

46

DEC 21 2016

AS

6

9-89

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.70

Quality Control

DAS

21

9-89

DEC 21 2016

DAS

21

9-89

DEC 21 2016

DQA: _____ Date: _____



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OTHER :									

Picklist Print

Thursday, December 08, 2016 11:15:33 AM

Page 1

Work Order ID: 154328

154328

Parent Item: D5406-1

D5406-1

Parent Item Name: Connector

Start Date: 12/2/2016

Required Date: 12/8/2016

Start Qty: 42.00

Required Qty: 42.00

Comments: IPP REV:A NEW ISSUE 16.06.06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	181.5400		0.747158			

M304S16GA

304/316 Sheet .063

on 12/12/17

Location

Loc Qty

Loc Code

MAT010

181.54

m136036

61.54

m136327

120

1.1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause			FAULT CATEGORY							
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Past Expiry Date ☐	☐	Manufacturing Process	☐ OTHER :							
Misidentified ☐	☐	Past Due								

INSPECTION SHEET

DAS

9

9-86

17.1

DQA: _____ Date: _____



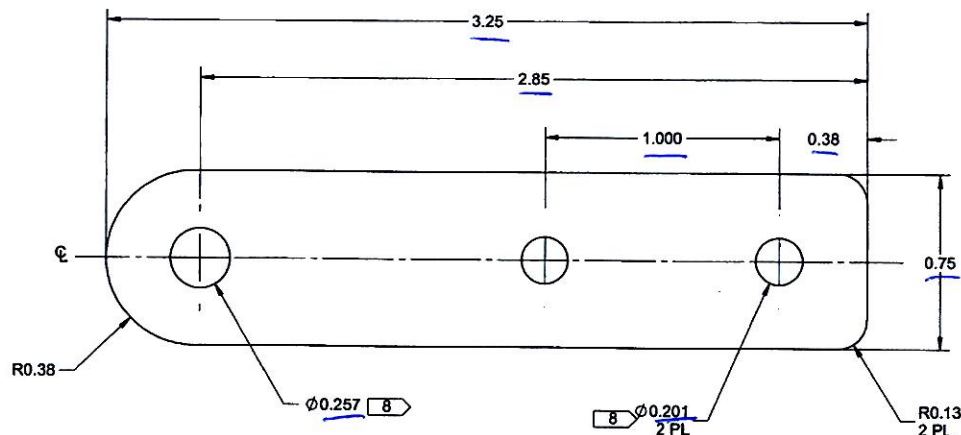
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 154328MWS
16-12-08



D5406-1 CONNECTOR

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
 ANNEALED, 2B FINISH
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC M304S16GA
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASED
 2016-11-24
 04

APPROVED

A		NEW ISSUE		VS	16.05.10
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	VS				
CHECKED	RF	DRAWING NO.	REV. /		
MFG. APPR.	JLM	D5406	SHEET 1 OF 1		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	CONNECTOR	NTS		
DATE	16.05.10		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____



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OTHER : _____					